Work Orde June-12-13 9:1		02841			*102	2841*			- <u></u>		<b>.</b>	Page 1
Item ID: Revision ID: Item Name:	D3027-5				Accept	*N900	<b>040</b>	100	)* s	etup Stai Sto	1.71	S1* S2*
Start Date: Required Date:	6/11/13 : 6/11/13	Start Qty: 10 Req'd Qty: 10		*10* *10*		Cust Item I Customer:	D:					
Reference: Approvals:	Process P QC:			Date:   3 - 6 - 1 - 2 -			ate:		R	tun Star Sto		R1* R2*
Sequence ID/ Work Center I	D	Operation Description			Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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D3027	Re	ev B	-,				_,					
*110*		HAAS CNC VER	TICAL M	ACHINING #1	0.00		<del></del>		(4)	. 2		Jn3-07-2
Waterjet FLOW CNC Water 2024 . 05		PRO	AS PER F G REV: G REV:	CILE B	0.00				_ 1,02.	<b>O_</b>	<u> </u>	
120		QC2- Inspect part		nine FAI/FAIB	0.00							1
*120 *120*		Mem			0.00				/.0.	ـ ـ ـ0.		Jm1207-2

Quality Control

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						DISPOSITION				AGAINST	DEF	PARTMENT	/PROCESS		
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						Rework			Skid-tube	Crosstube	_		Water Jet	Engineering	
Part N	۷o					Scrap			Machining	Small Fab	⊢		d. Eng. Coor.	Quality	
						Use-as-is		Thern	noforming	Finishing	-	Rec/Stor	re/Packaging	Other	
NCR N	No	_				Suspected Unapproved			Large Fab	Composite			Supplier	ن ل	
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	⊢		t Concer	ntric	-	BOM/Route	<u> </u>	Grain			-	Over/Under	) <del>-</del>	Set-up	
	<del>⊦</del> ⊣	acks			<u> </u>	Broken/Damage/Defect		Hardwa			<b>├</b> ──	Part Incorred	<u> </u>	Temperature/Cure	
	${f -}$		k/Ripple	/Wave	-	Burrs	_	1	ion Incomplete/U		-	Part Lost/Mi		Weld .	
	⊢ Cu				-	Contamination	<u> </u>	4	tions Incomplete/	Unclear	-	Part Moved	<u> </u>	Wrong Stock Pulled	
	$\vdash$	ushing _			$\vdash$	Countersink	<u> </u>	-	gned/off center		-	Positioned V		$\neg$ .	
	$\vdash \vdash$	at Trea			<u> </u>	Cut Too Short	-	Mislabe			Ш	Power Loss/	Surge	Other	-
l	${oldsymbol{ o}}$	•	Strip in	Tube	-	Drawing	_	Misread							_
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	_	-	equence		_	Finish	L_	1	Calibration						-
	[_ [W	ave/Twi	ist in Tub	oe -		Fit/Function	1	Out of:	Sequence						

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Work Ord		2841 		*102	841*	<u>-</u>	<b>.</b>	· .		Page 2
Item ID: Revision ID: Item Name:	D3027-5			Accept	*N900040	100	*	Setup Star	1 11	S1* S2*
Start Date: Required Date Reference:	6/11/13 : 6/11/13	Start Qty: 10.00 Req'd Qty: 10.00	*10° *10°		Cust Item ID: Customer:					
Approvals:	Process Pla	n:	Date:		Date:	 		Run Sta Sto	" <b>  \]</b>	R1* R2*
Sequence ID/ Work Center I 130 *130* QC Quality Control	 D	Operation Description QC8- Inspect parts - secon	nd check	Set Up/ Run Hours 0.00 37.8	Tool ID Tool #	Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
* <b>1 4 0</b> * Small Fab Small Fab		Small Fab Memo		0.00			<u>/o</u>		<del>-</del>	\$3/00/2
*150 *150* QC	•	Bend as per of QC5- inspect part comple		DAS 27 0.00 9-89 0.00  3.8-	۵)	<u> </u>	6			· · ·

Quality Control

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مه دامه ا		Data			WORK ORDER NON-	-CC	ONFO	RMANCE / UPDATE	14/	ork Order up	ndata anly - F		AEROSPACE
QA Closed:		Date:						<del></del>		ork Order up	date only		
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WOOK OT GE				<u> </u>	Rework	1		Skid-tube Crosstu	<sub>ibe</sub>	1	Water Jet	T E	ngineering
Part N	lo.			i i	Scrap			Machining Small F	_	Pro	d. Eng. Coor.	7 -	Quality
					Use-as-is			noforming Finish	· -	-	e/Packaging		Other
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										- 			
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Landi	ng Gear				General								<del>-</del>
	Bending	!			Bend	Г	Folio/F	rogram		Outside Dim	ensions [	Pre	ssure/Forced
	<del>-</del>	Not Conce	ntric		BOM/Route		ہن Grain	_		Over/Under	tolerance	<b>⊣</b>	-up
	Cracks				Broken/Damage/Defect	_	Hardwa	re		Part Incorred	rt [	Ten	nperature/Cure
	Crimp/K	ink/Ripple	e/Wave		Burrs		Inspect	ion Incomplete/Unqualified		Part Lost/Mi	ssing	Wei	ld
ı	Cuffs				Contamination		Instruct	ions Incomplete/Unclear		Part Moved	[	Wro	ong Stock Pulled
	Crushin	g			Countersink		Misalig	ned/off center		Positioned V	Vrong		
	Heat Tre	eat			Cut Too Short		Mislabe	eled		Power Loss/	Surge	Oth	ier
	Inspecti	on Strip in	1 Tube		Drawing		Misread	t					
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	Turning	Sequence	<u> </u>		Finish		Out of (	Calibration					
	Wave/T	wist in Tul	he	- [	Fit/Function	1	Dut of	Sequence					

Work Orde June-12-13 9:1.		2841	· · · · · · · · · · · · · · · · · · ·	*1028	41*				Page 3
Item ID: Revision ID: Item Name:	D3027-5			Accept *	N9000	74010	<b>n*</b>	Setup Sta	10.51
	6/11/13	Start Qty: 10.00 Req'd Qty: 10.00	*10* *10*		Cust Item ID Customer:	<b>)</b> :			
Approvals:		an:	Date:	Tooling:	Dat	te:	-	Run Sta	"NRT"
Sequence ID/ Work Center II 160 *160* HandFinish Hand Finishing	· ·	Operation Description Chemical Conversion Coa	t per QS1005 4.1	Set Up/ Run Hours 0.00	Tool ID	Tool # Plan Code		Qty	Reject Insp. Number Stamp
170 *170* QC Quality Control		QC3- Inspect Part Finish  Memo		0.00 0.00 B & D	1		10	· · · — ——	

180

Identify as per dwg & Stock Location: 5TO24 0.00

\*180\* Packaging

Packaging Memo

Packaging

0.00

10x M.D. 13-08-25

DQA:		_	Date:		-	WORK ORDER NON	.cc	NΕΩΙ	RMANCE / HDDATE					<b>DART</b>
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i	_					Rework			Skid-tube Crosstube			Water Jet		Engineering
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	c	racks				Broken/Damage/Defect		Hardwa	are		Part Incorre	ct		Temperature/Cure
	c	rimp/Kir	nk/Ripple	/Wave		Burrs	Г	Inspect	ion Incomplete/Unqualified		Part Lost/Mi	ssing		Weld
	c	uffs				Contamination		Instruct	tions Incomplete/Unclear		Part Moved	[		Wrong Stock Pulled
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		_	ist in Tub	ie		Fit/Function		4	Sequence					

Work Orde June-12-13 9:1		2841		*102	2841*	<u> </u>						Page 4	l -=- ;
Item ID: Revision ID: Item Name:	D3027-5			Accept	*N900	ก4ก	100	)* ·	Setup	Start Stop	ı V.	S1* S2*	,
Start Date: Required Date: Reference:	6/11/13 : 6/11/13	Start Qty: 10.00 Req'd Qty: 10.00	*10* *10*		Cust Item II Customer:	D:	_			Stant			
Approvals:		an:	Date:			te:		ľ	Run	Start Stop		R1* R2*	
Sequence ID/ Work Center I	D	Operation Description		Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Rej Qty	•	Reject Number	Insp. Stamp	, -
*190 *190* QC		QC21- Final Inspection -	WORK Order Release	0.00				M_C	.エ_	13-1	08-23		ı

Quality Control

\$13-08-22

DQA:		Date:							224				*DART
QA Closed:		Date:			WORK ORDER NON-	-C(	JNFOI	RMANCE / U		Wo	rk Order up	odate only	AEROSPACE
18 ( a. al. O a d a					DISPOSITION				AGAINST	DEP	ARTMENT	/PROCESS	
Work Orde	er:	•			Danie at	ì		Skid-tube	Crosstube			Water Jet	Engineering
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Part N	····				Use-as-is			noforming	Finishing	$\vdash$		re/Packaging	Other
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	Cracks	ı			Broken/Damage/Defect		Hardwa	re		$\square$	Part Incorre	ct	Temperature/Cure
ĺ	Crimp	/Kink/Ripple	e/Wave		Burrs		Inspect	ion Incomplete/U	nqualified		Part Lost/Mi	issing	Weld
ĺ	Cuffs				Contamination		Instruct	ions Incomplete/	Unclear		Part Moved		Wrong Stock Pulled
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ĺ	Heat T	reat			Cut Too Short		Mislabe	eled			Power Loss/	Surge	Other
	inspec	tion Strip in	1 Tube		Drawing		Misread	ŧ					
ĺ	Marks	/Chatter			Drill Holes		Off-set			_			
	Turnir	g Sequence	<u> </u>		Finish		Out of 0	Calibration		_			
	Wave	Twist in Tu	be		Fit/Function		Out of	Sequence					

June-12-13 9:15:11 AM

Work Order 1D:

102841

Parent Item:

Comments:

Parent Item Name:

Clip

D3027-5

B01.09.27Now goes on HAASSM

Start Date: 6/11/13

Required Date: 6/11/13

Start Qty: 10.00

Required Qty: 10.00

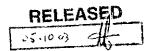
Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M2024T3S.050 2024-T3 .050 sheet		Purchased	No			100	sf	179.1920	0.0312	0.328421 0.5		J <sub>P</sub>	1130775

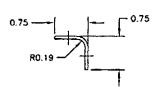
Loc Code Loc Qty Location MAT022 179.192 124643 124643 179.192

DQA:			Date:	<u> </u>										TOART
QA Closed:			Date:			WORK ORDER NON-	·CC	ONFO	RMANCE / U		Work Order	update only		AEROSPACE
		-				DISPOSITION				AGAINST (	DEPARTME	NT/PROCESS		
Work Ord	er: _	·				_				_	<del></del>			🖂
	Order:  Part No.  NCR No.  Date Step Qty  a coling gy/Pre coved co					Rework		•	Skid-tube	Crosstube	_	Water Jet	-	Engineering
Part I	No	<u>-</u>				Scrap			Machining	Small Fab	<del>-</del> -	rod. Eng. Coor.	-	Quality
						Use-as-is			noforming	Finishing	⊢ Rec/S	tore/Packaging	-	Other
NCR I	art No.  CR No.  Date Step Qty  oling			Suspected Unapproved	. 1		Large Fab	Composite		Supplier				
Root					Desci	ription of work order update	i	nitial	Ac	tion	Sign &			
Cause		Date	Step	Qty		or non-conformance	Ch	ief Eng	Desc	ription	Date	Verification	n	QC Inspector
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Transport				İ			ļ					İ	İ	
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							FAI	ULT CAT	EGORY					
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	-	-			<u> </u>	Bend		1	rogram		<del></del> 1	Dimensions	$\vdash$	Pressure/Forced
	-		ot Concer	ntric	<u> </u>	BOM/Route	<u> </u>	Grain		-	<del>_</del>	der tolerance	-	Set-up
	Н					Broken/Damage/Defect	<u> </u>	Hardwa			Part Inco		$\vdash \vdash$	Temperature/Cure
	<b>-</b>		nk/Ripple	/Wave	 	Burrs		1	on Incomplete/U	·	Part Lost,	_	$\vdash$	Weld
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1	$\vdash$					Cut Too Short		Mislabe		į	Power Lo	ss/Surge	Ш	Other
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	-	Turning S				Finish		Out of 0	Calibration					· · · · · · · · · · · · · · · · · · ·
		Wave/Tw	ist in Tub	ne .		Fit/Function	į	lout of 9	Sequence					

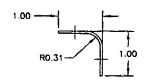


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CHEC	KED J	APPROVED A	DRAWING NO. REV. 6
	献	#	D3027 SHEET 1 OF 2
DATE			TITLE SCALE
05.0	9.20		CLIP 1:2
Α		01.05.18	NEW ISSUE
В		05.09.20	REMOVE HOLES FROM -7

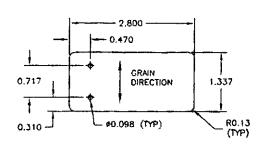




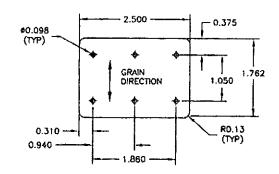
03027-1 BEND DETAIL



D3027-3 BEND DETAIL



0.3027-1 FLAT PATTERN (0.063" SHEET)



D3027-3 FLAT PATTERN (0.050" SHEET)

## NOTES:

- 1) BREAK ALL UNMARKED SHARP CORNER 0.010 TO 0.020
- 2) MATERIAL: 2024-T3 (QQ-A-250/4)
- 3) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

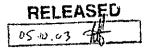
Copyright © 2001 by DART AEROSPACE LTD

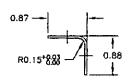
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DQA:	. <u> </u>	Date	:		,			_						DART
QA Closed:		Date	:		WORK ORDER NON	-C(	ONFO	RMANCE / U	PDATE	w	ork Order up	ndate only - F	7	AEROSPACE
			·		DISPOSITION				AGAINST		PARTMENT	<del> · '</del> _ <u> </u>		
Work Orde	er:				0137 03111014				AGAINST		-	/FROCE33		
		•			Rework	]		Skid-tube	Crosstube			Water Jet	En	gineering
Part N	No				Scrap	]		Machining	Small Fab		Pro	d. Eng. Coor.		Quality
					Use-as-is	]	Thern	noforming	Finishing	L	Rec/Sto	re/Packaging	_	Other
NCR N	NCR No.  Date Step Qty  ata   (Tooling				Suspected Unapproved	]		Large Fab	Composite		j	Supplier		
Root				Desci	ription of work order update	ı	Initial	Act	tion		Sign &			
Cause	Dat	e Step	Qty	<u> </u>	or non-conformance	Ch	nief Eng	Desc	ription		Date	Verification	(	QC Inspector
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	Cuffs			$\vdash$	Contamination		-1	ions Incomplete/	Unclear	_	Part Moved		Wro	ng Stock Pulled
	Crushi	-			Countersink	Ŀ	-	ned/off center		_	Positioned V	· ·	_	
	Heat T			<u> </u>	Cut Too Short	<u></u>	Mislabe			Ŀ	Power Loss/	Surge [	Othe	r
	— —	tion Strip ir	1 Tube	<u> </u>	Drawing	$\vdash$	Misread							
	_	/Chatter			Drill Holes	<u></u>	Off-set							
	_	g Sequence		_	Finish		1	Calibration						
	l Wave	Twist in Tu	he	ì	Fit/Function	1	Dut of 9	Sentience						

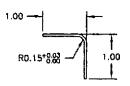


DESIGN RF	DRAWN BY		ROSPACE LTD RY, ONTARIO, CANADA
CHECKED A	APPROVED JA	DRAWING NO.	REV. β
- H	dff-	D3027	SHEET 2 OF 2
DATE	<u> </u>	TITLE	5CALE
05.09.20		CLIP	1:2

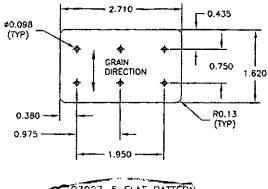




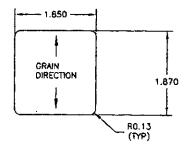
D3027-5 BEND DETAIL



D3027-7 BEND DETAIL



03027-5 FLAT PATTERN (0.050" SHEET)



03027-7 FLAT PATTERN (0.050" SHEET)

## NOTES:

- 1) BREAK ALL UNMARKED SHARP CORNER 0.010 TO 0.020
- 2) MATERIAL: 2024-T3 (QQ-A-250/4)
- 3) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

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DQA:		_ Date:	: <u></u>		_							TOACE		
					WORK ORDER NON	-C(	ONFO	RMANCE / L	JPDATE					AEROSPACE
QA Closed:		Date:	:		Work Order update only									
Work Order:					DISPOSITION				AGAINST	DE	PARTMENT	/PROCESS		
				_	Rework	]		Skid-tube	Crosstube		]	Water Jet	_	Engineering
Part N	o.				₽ ⊨⊸IJ		Machining	Small Fab	<b>⊢</b> —	Prod. Eng. Coor.		$\vdash$	Quality	
					Use-as-is		I	noforming	Finishing	⊢	4	re/Packaging	_	Other
NCR N	NCR No.			Suspected Unapproved	֓֓֓֓֓֓֓֓֓֓֓֓֓֓֓֓֓֓֓֓֓֓֓֓֓֓֓֓֓֓֓֓֓֓֓֓֓	1 1		Composite		Supplier		-		
Root				Desci	ription of work order update		Initial	A	ction		Sign &			
Cause	Date	Step	Qty		or non-conformance	Ch	nief Eng	Desc	cription		Date	Verificatio	n_	QC Inspector
Design									<u>-</u>					
Doc/Data									• *					
Equip/Tooling	_			1										
Handling/Pre	_										•			
Material					1									
Operator														
Offset/Setup	_													
Process	_				1						<u>'</u>			
Supplier	_													
Training														
Transport	_			ł	1	1								
Unapproved		<del></del>									<u>L</u>			
						FAI	ULT CAT	EGORY			-			
Landin	g Gear		•	r-	General		1				٦	•	_	1
-	Bending				Bend	<u> </u>	1	rogram		_	Outside Dim		L	Pressure/Forced
	_	Not Conce	ntric	_	BOM/Route	<u> </u>	Grain	in		L	Over/Under tolerance		┕	Set-up
-	Cracks			Broken/Damage/Defect	Hardwar		ardware			Part Incorred		L	Temperature/Cure	
	Crimp/Kink/Ripple/Wave			Burrs	<u> </u>	Inspecti	on incomplete/L	Jnqualified	L	Part Lost/Mi	<del>-</del>	_	Weld	
Ļ	Cuffs			<b>—</b>	Contamination	<u> </u>	-	ions Incomplete	` <del> </del> 1		Part Moved		L	Wrong Stock Pulled
<u> </u>	Crushing			_	Countersink	<u> </u>	1 "	ned/off center	•	_	Positioned Wrong		_	1
-	Heat Treat			-	Cut Too Short	<u> </u>	Mislabe				Power Loss/	Surge	L	Other
1	<del></del> -1	on Strip in			Drawing		Misread	j						
<u> </u>	<del></del> -	Chatter		<u> </u>	Drill Holes		Off-set							
	<b>⊸</b> 1 "	Sequence			Finish	_	4	Calibration						
<u>.</u>	Wave/Twist in Tube			L	Fit/Function		Out of 9	Sequence						

DART AEROSPACE LTD	Work Order:	10-2841		
Description: Clip	Part Number:	D3027-5		
Inspection Dwg: D3027 Rev: B		Page 1 of 1		

FIRST ARTICLE INSPECTION CHECKLIST								
	х	First Arti	cle	Prot	otype			
Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments		
2.710	+/-0.010	2.714"	_		ν	JEMOI		
0.435	+/-0.005	0.437"	-		V			
0.750	+/-0.005	0.751	-		V			
1.620	+/-0.010	1.623	_		V			
R0.13	+/-0.030	0.13"	-		RG			
1.950	+/-0.005	1.954	_	_	ν			
0.975	+/-0.005	0.975"	_		V			
0.380	+/-0.005	0.381	_		٧			
Ø0.098	+0.005/-0.000	0.095	=		<b>V</b>			
			04					

Measured by: JM	Audited by:	Prototype Approval:	N/A
Date: (3-07-25	Date: 15 J.J.	Date:	N/A

Rev	Date	Change		Revised by	Approved
Α	05.04.26	New Issue	P/O D350-689-013	KJ/JLM , a	- 1
В	06.03.09	Dwg Rev upated		KJ/JLM	Sill

DQA: Date:				WORK ORDER NON		ONIE ()	PMANCE / HDDATE				*DART		
QA Closed:			Date:			WORK ORDER NON	N-CONFORMANCE / UPDATE  Work Order update only						AEROSPACE
Work Order:					DISPOSITION			AGAINS	r DE	PARTMENT/PROCESS			
Part No.  NCR No.				Rework Skid-tube Crosstub Scrap Machining Small Fa Use-as-is Thermoforming Finishin Suspected Unapproved Large Fab Composit		ab Prod. Eng. Coor. ng Rec/Store/Packaging			Engineering Quality Other				
Root					Desci	iption of work order update		nitial	Action		Sign &		
Cause		Date	Step	Qty		or non-conformance	Ch	ief Eng	Description		Date	Verification	QC Inspector
Design Doc/Data Equip/Tooling Handling/Pre Material Operator Offset/Setup Process Supplier Training Transport Unapproved													
							FAI	JLT CA1	TEGORY				
Cuffs Crushing Heat Treat Inspection Strip in Tube Marks/Chatter			General Bend BOM/Route Broken/Damage/Defect Burrs Contamination Countersink Cut Too Short Drawing Drill Holes Finish		Grain Hardwa Inspecti Instruct Misalig Mislabe Misread Off-set	ion Incomplete/Unqualified ions Incomplete/Unclear ined/off center iled		Outside Dim Over/Under Part Incorred Part Lost/Mi Part Moved Positioned W Power Loss/S	tolerance et ssing frong	Pressure/Forced Set-up Temperature/Cure Weld Wrong Stock Pulled Other			
-	Wave/Twist in Tube				Fit/Function		l	Sequence			<del></del>		